

Date: Monday, 12/01/2009 2:31:04 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 412 WEB

Job Number : 44577

Estimate Number : 10466

P.O. Number :

Part Number : D33891

This Issue : 12/01/2009 S.O. No. :

Drawing Number : D3389 REV D

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SKIDTUBES

Drawing Revision : D

Previous Run : 44576

Material :
Due Date : 26/01/2009

Qty:

4
 1 Um: Each

Written By :

Checked & Approved By :

Comment :

2009.01.12
 Est Rev:A 05.08.31 New issue KJ/JLM
 Est Rev:B 06-02-08 As per Rev C JLM
 Est Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified
 by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D25003100

Ext'n - 'I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ext'n - 'I' Beam Web 4"

Pick:

Qty

Part Number

Description

Batch

D2500-3-100

Web Extrusion

B-40196 AWM 9-2-26

2.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open holes to finish size as per Dwg D3389

4-Deburr

AWM 9-2-26

3.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M. 09-02-26

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *L-G*

AWM 9-2-26

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



MF 09-02-27

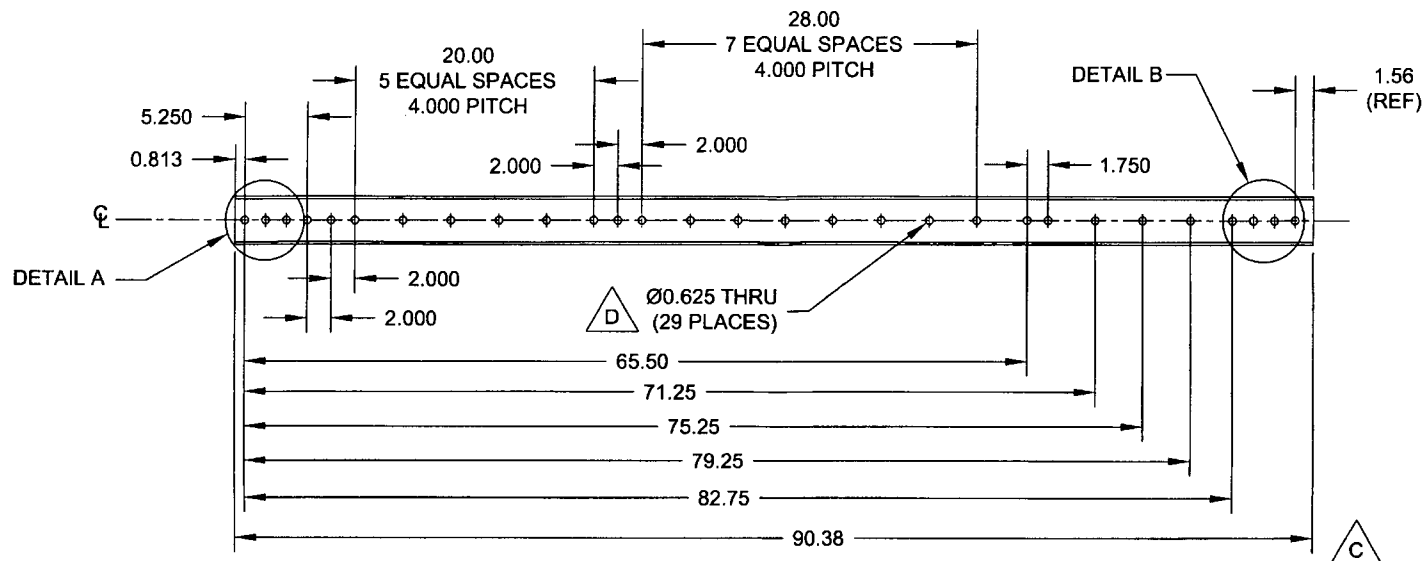
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

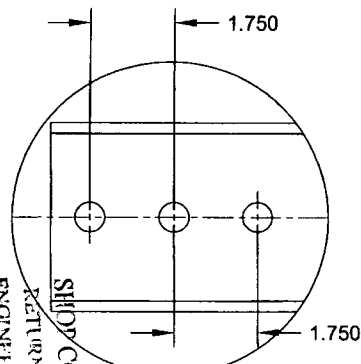
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

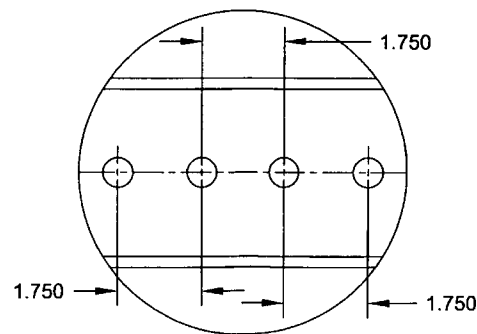
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5









DETAIL B
SCALE 2:5

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SUBMIT TO AN APPROVED
W. A. D. F. NOTE

- NOTES**
- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DRAWING NO.	REV. D
		D3389	SHEET 1 OF 1
		TITLE	SCALE
		412 WEB	1:10
DATE	07.10.09	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	